

# Work Order ID 75464

\*75464\*

Page 1

October 24, 2011 9:45:44 AM

Item ID: D3188-2M Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: SPACEPOD BODY RH  
 Start Date: 10/24/11 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 11/09/11 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: CL Date: 11/10/24 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3188	Rev F								

100 PURCHASING 0.00  
 \*100\*  
 Purchasing Memo 0.00  
 Purchasing Issue P/O: 15233  
 Description: D3188-2MBODY  
 SHIP: QTY (8) D2213 Spacers  
 Supplier: Delastek 330809  
 Conformity Certificate and Process sheet required  
 Ship 2 Items from Previous steps

CL 11/10/24 1

110 Receive & Inspect for Damage & Mat'l Certs 0.00  
 \*110\*  
 Packaging Memo 0.00  
 Packaging Ensure a copy of certification of conformity and process sheet from Delastek is attached.

40/4/08 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 75464****\*75464\***

Page 2

October 24, 2011 9:45:44 AM

Item ID: D3188-2M Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: SPACEPOD BODY RH  
Start Date: 10/24/11 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 11/09/11 Req'd Qty: 1.00 **\*1\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC6- Inspect dimensions to drawing  Memo Check for void spot and pins.	0.00  0.00		8063/29					
130 <b>*130*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>composites</u>  Memo	0.00  0.00				85	12-03-29		
140 <b>*140*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							12/3/29 mf 12-03-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

October 24, 2011 9:45:43 AM

Page 1

Work Order ID: 75464

Parent Item: D3188-2M

Start Date: 10/24/11

Required Date: 11/09/11

Parent Item Name: SPACEPOD BODY RH

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New issue ecn882 06-11-30 EC  
 IPP rev B rev D dwg 07.03.07 ec  
 IPP rev C rev E dwg 07.04.16 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2213. / Insert		Manufactured	No			100	Each	162.0000	8	8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST008		162							
				30809		162							
D3188-2P Spacepod Body		Purchased	No			110	Each	0.0000	1	1			

B75464

CL 11/10/25

8

12 03 29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

GENERAL NOTES:

1) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")  
18 oz ROVING "E" GLASS (18 oz CLOTH)  
OWENS CORNING MILLED FIBERS, "E" GLASS  
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL  
OR DIVINYLCELL  
OR AIREX  
OR KLEGECELL  
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

1. MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.  
APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D3188-1 = N/A  
D3188-2 = N/A  
D3188-3 = N/A  
D3188-5 = N/A  
D3188-6 = N/A  
D3188-7 = N/A

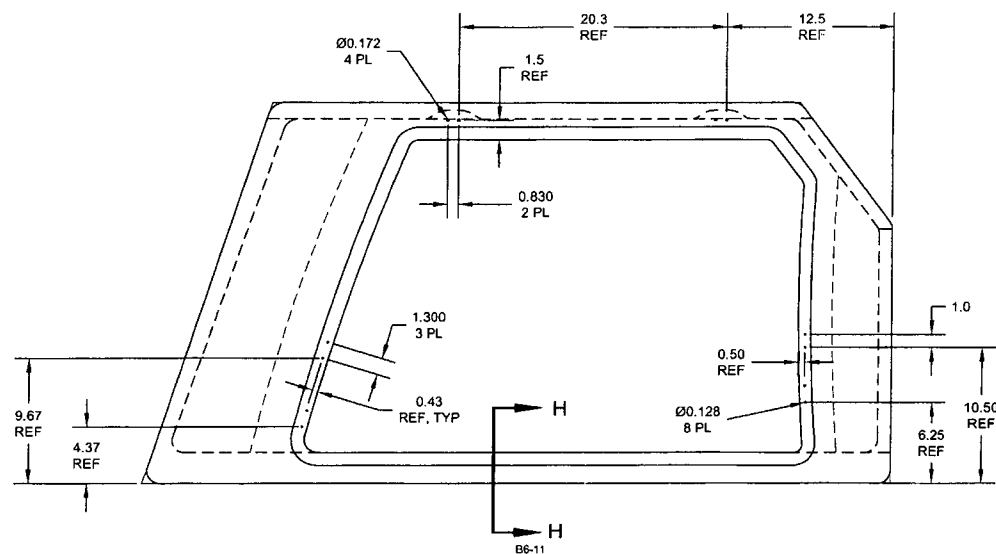
8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING

9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

C21110124  
W10. 75464

RELEASED  
2009-10-20

F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL/ FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	CB	06.10.06
A	NEW ISSUE	CP	03.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 1 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
DATE	09.07.13	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NOT TO BE REPRODUCED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



**D3188-1 SPACEPOD BODY**  
MAKE FROM D3188-1M

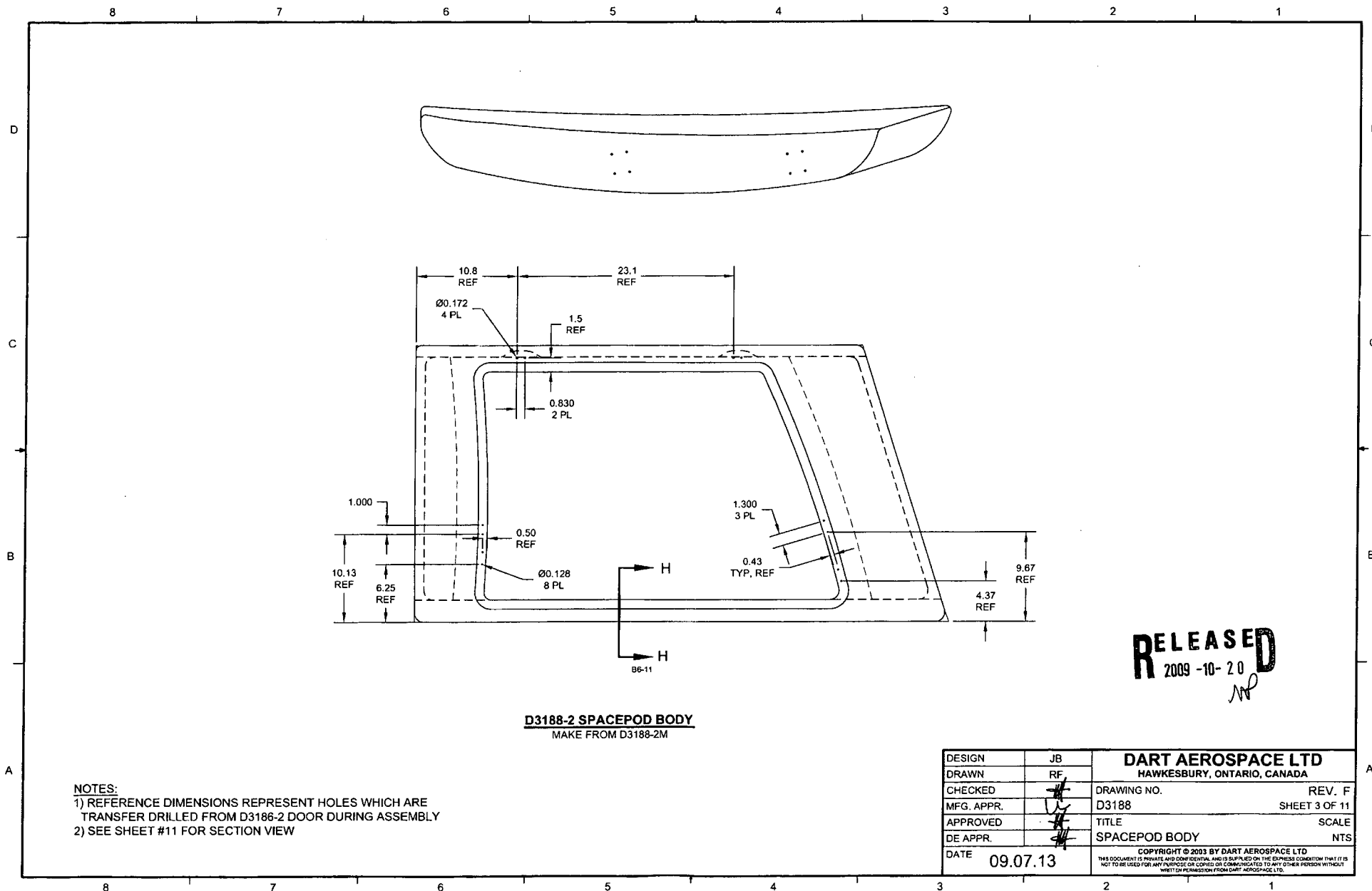
**NOTES:**

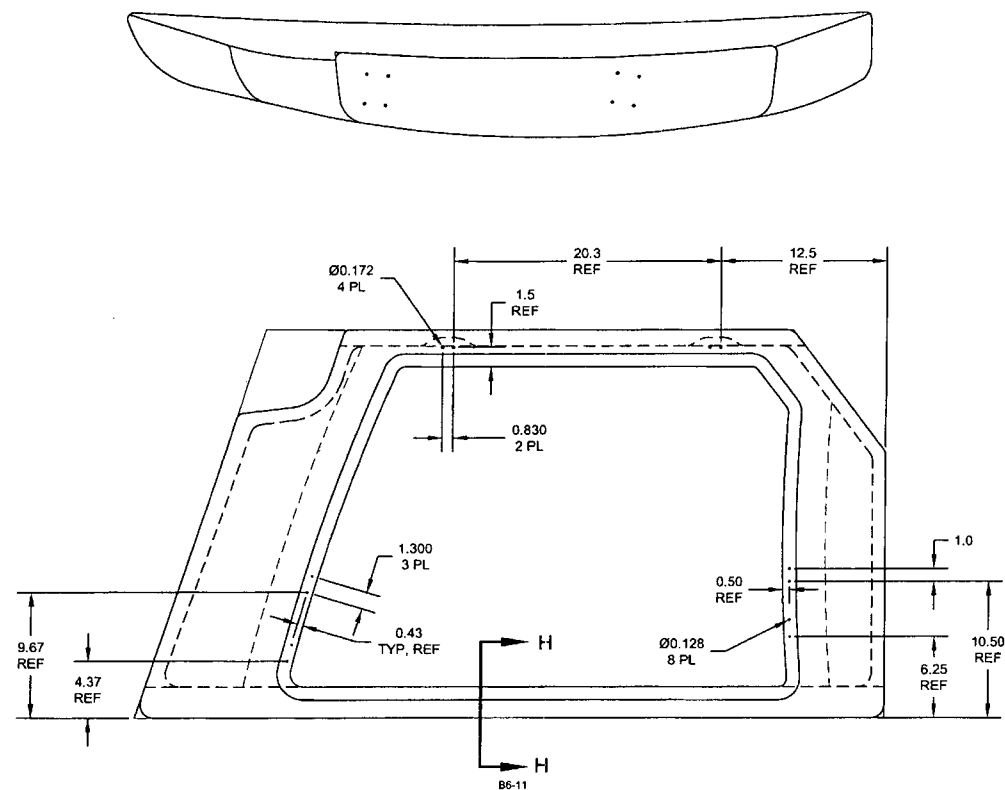
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

**RELEASED**  
2009-10-20  
*AW*

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 2 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
DATE	09.07.13	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	







**D3188-3 SPACEPOD BODY**  
MAKE FROM D3188-3M

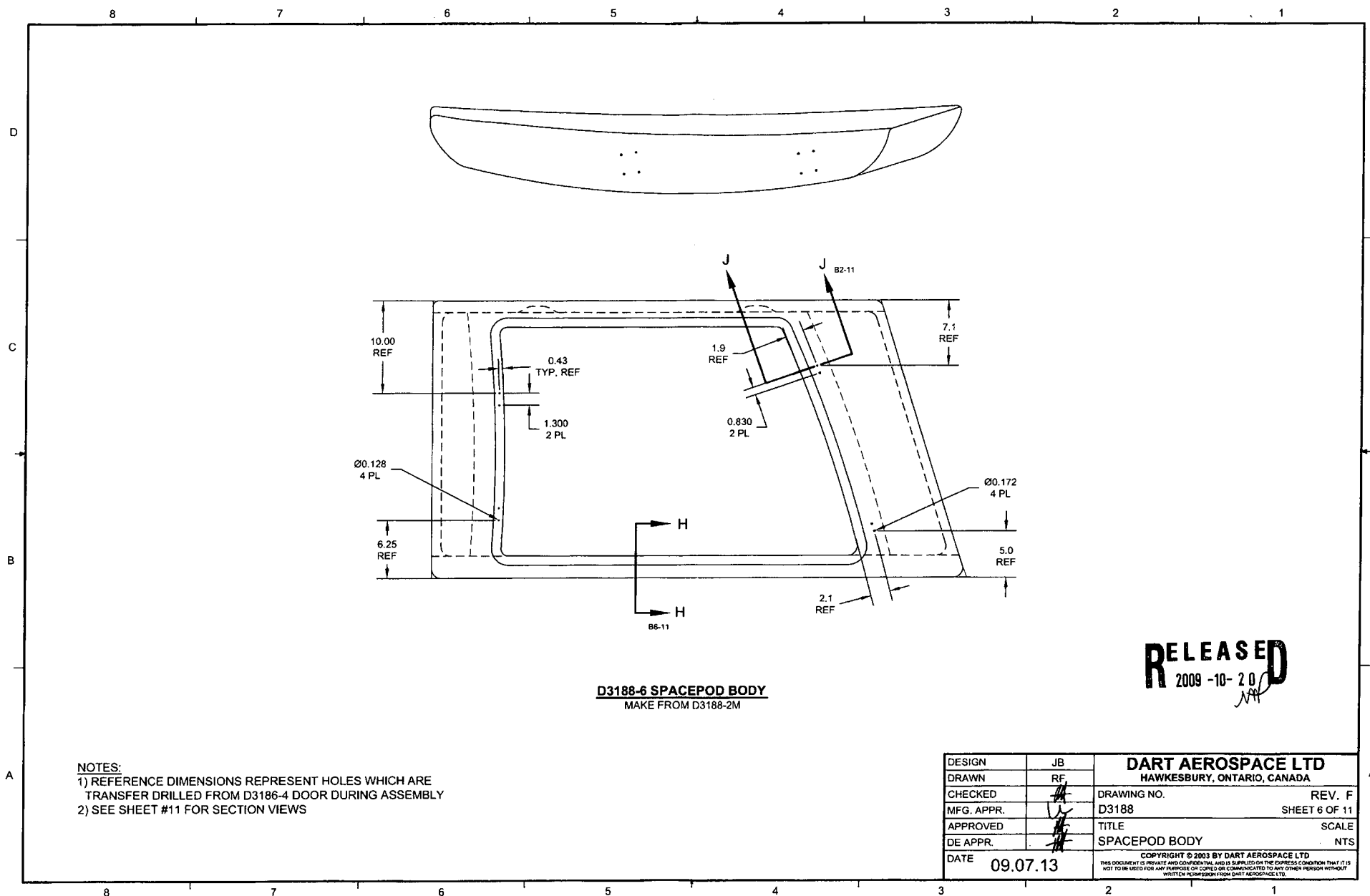
**RELEASED**  
2009-10-20

**NOTES:**

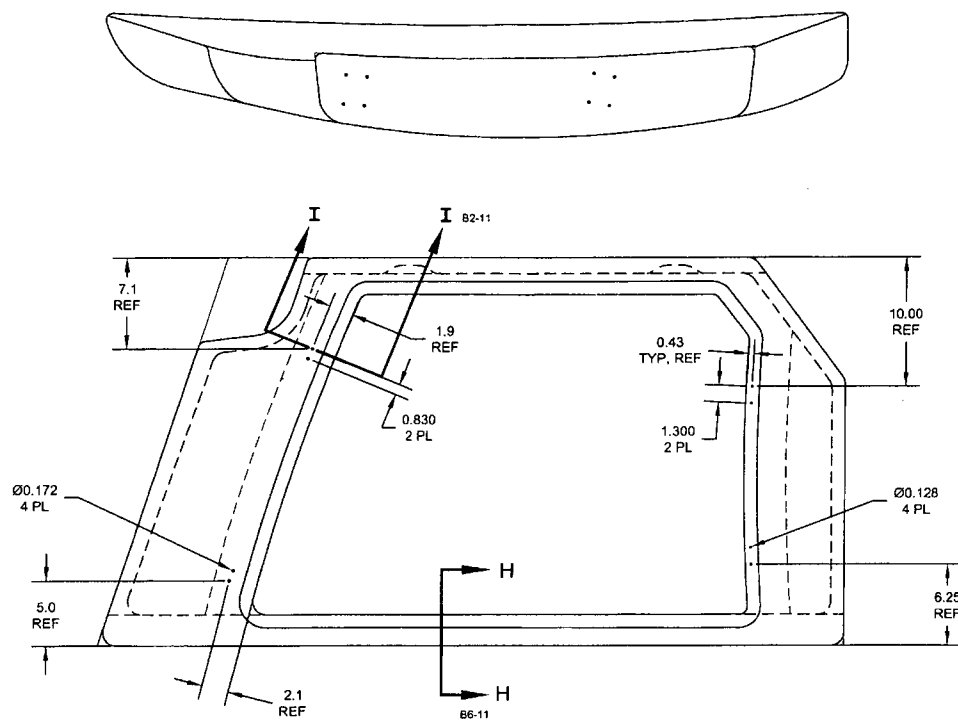
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 4 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
DATE	09.07.13	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	





**RELEASED**  
2009-10-20







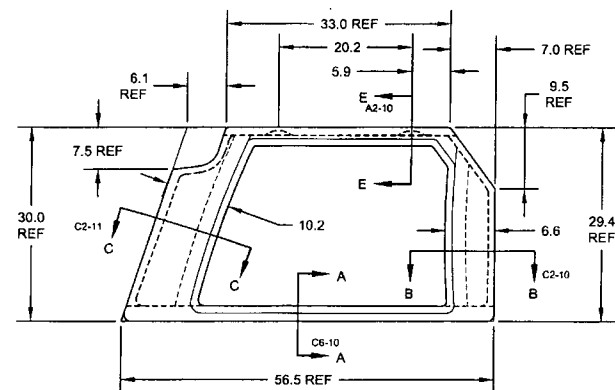
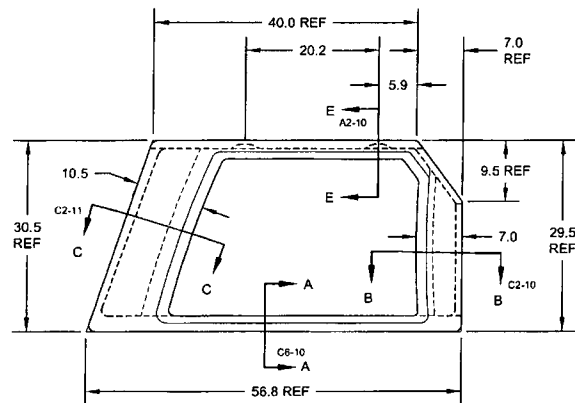
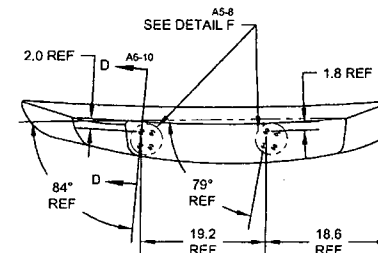
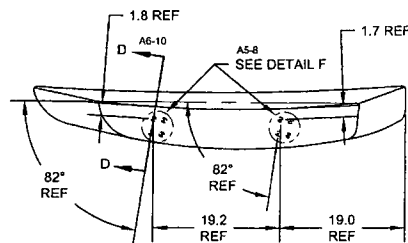
**D3188-7 SPACEPOD BODY**  
MAKE FROM D3188-3M

**NOTE:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

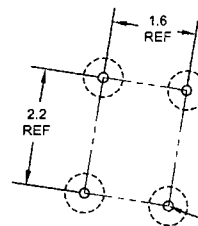
**RELEASED**  
2009-10-20

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3188	SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
DATE	09.07.13	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



**D3188-1M SPACEPOD BODY**

**D3188-3M SPACEPOD BODY**



**DETAIL F**

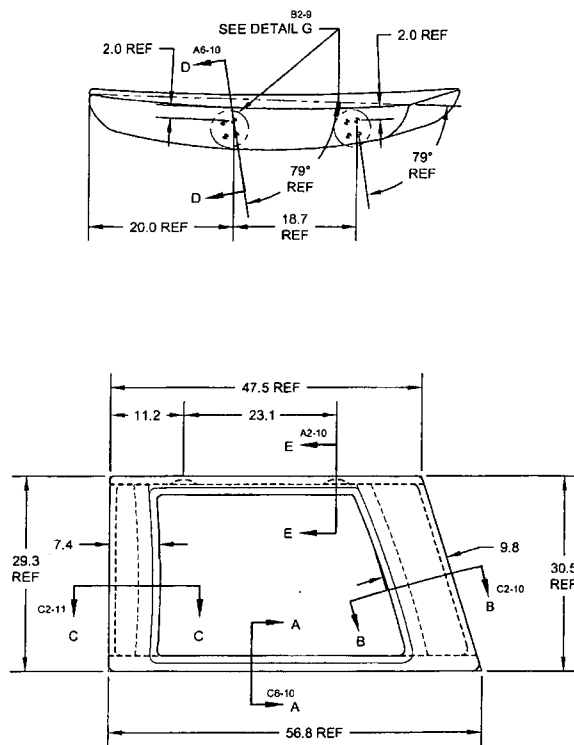
INSTALL  
D2213 SPACER  
8 PL  
SEE SECTION D-D  
A6-10

**D3188-1M/-3M NOTES:**

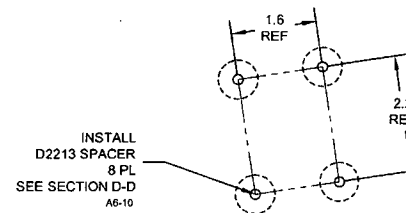
- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

**RELEASED**  
2009-10-23

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>JB</del>	DRAWING NO.	REV. F
MFG. APPR.	<del>JB</del>	D3188	SHEET 8 OF 11
APPROVED	<del>JB</del>	TITLE	SCALE
DE APPR.	<del>JB</del>	SPACEPOD BODY	NTS
DATE	09.07.13	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



**D3186-2M SPACEPOD BODY**



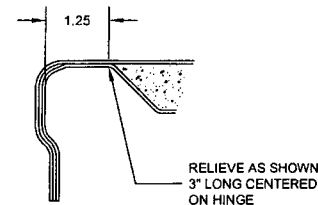
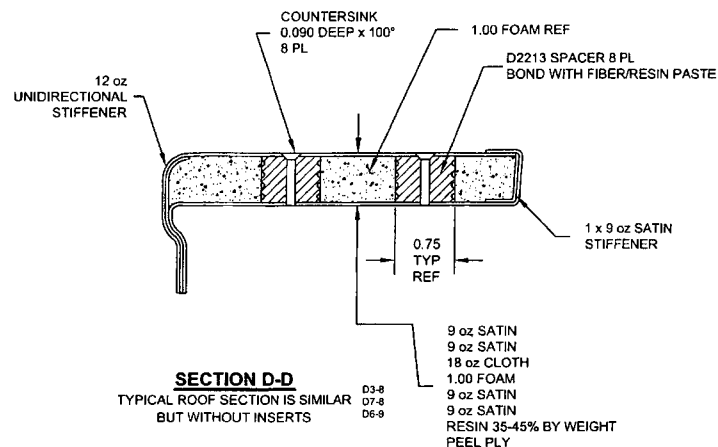
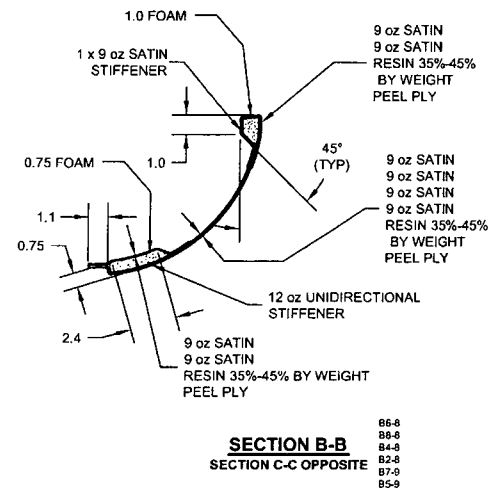
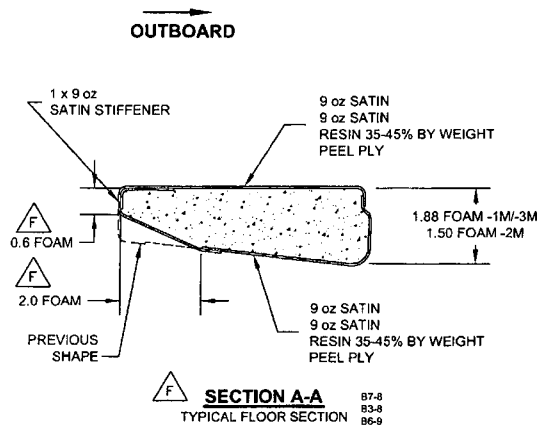
**DETAIL G** D6-9

**D3186-2M NOTES:**

- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

**RELEASED**  
2009-10-20





DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 9 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
DATE	09.07.13	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



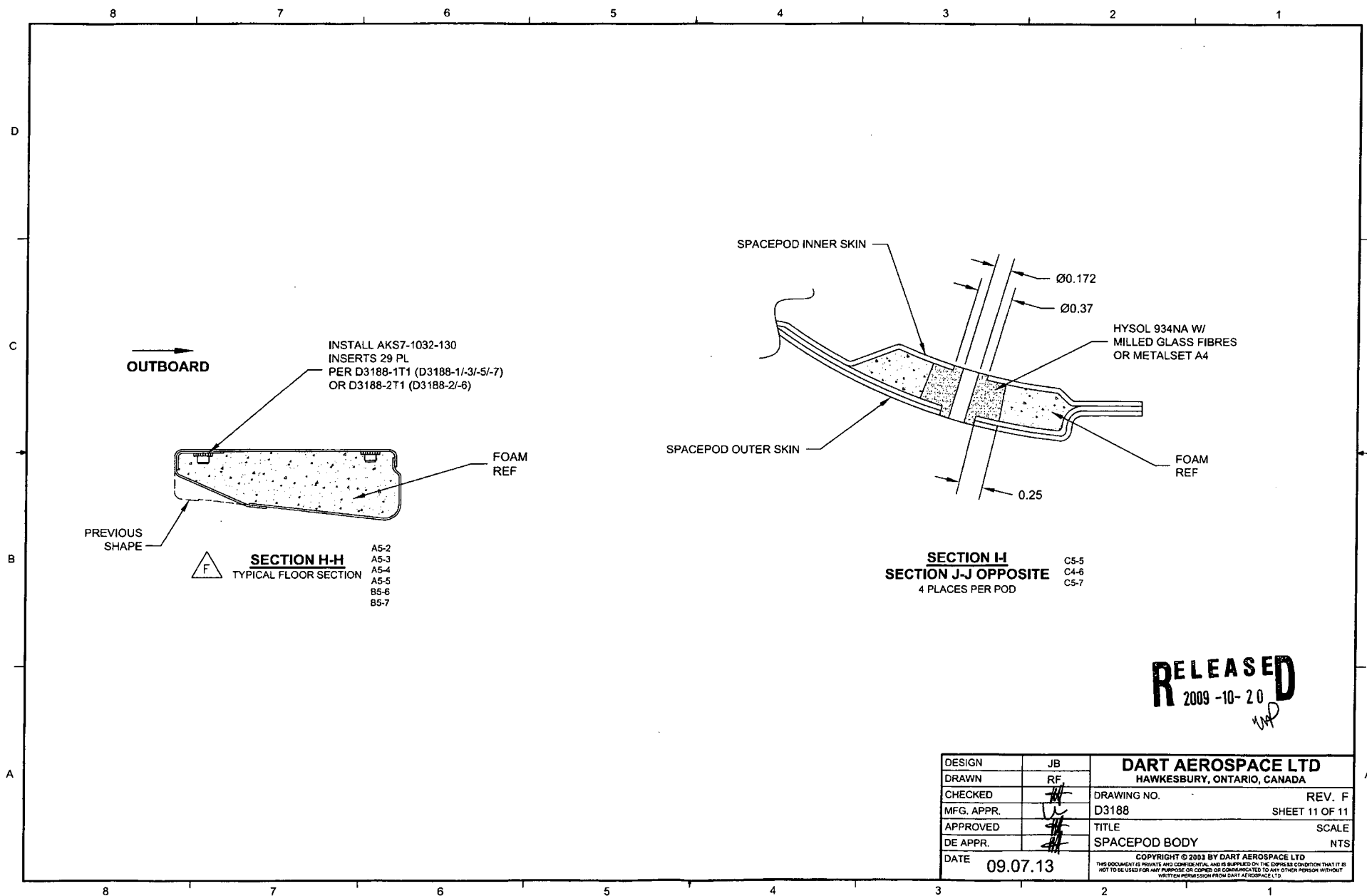
**SECTION E-E**  
2 PLACES PER POD

C2-8  
C7-8  
88-9

**RELEASED**  
2009-10-27  
JW

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3188	SHEET 10 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
DATE	09.07.13	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			





**RELEASED**  
2009-10-20

DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 11 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
DATE	09.07.13	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Date: Jeudi, 2011-04-21 11:52:58  
Utilisateur: Pascal Carignan

# Feuille de Procédé

Client : DART US DART AEROSPACE LTD  
Numéro Job : 32822  
Numéro Soumission : 3763  
Numéro B.A. :  
Cette fois : 2011-04-21 No. B.V. :  
Prsht Rev. : NC  
Prem. fois : Type :  
Job précédente : 32790  
Écrit par :  
Vérifié & Approuvé par :  
Commentaires : N° de pièce Client: D3188-2

Nom Dessin : SPACEPOD BODY RH  
Numéro Article : DKC134-0071  
Numéro Dessin : D3188  
Projet Numéro : DK-362  
Révision dessin : F  
Matériel : Fibre 7781 et résine 411-350  
Date Due : 2011-04-28 Qté: 1 UdM: UNITE

**B 75464**

Process Sheet Rév.: 03 changer le sikkens AAC1390 pour le P15-3  
(AAC1492), enlever le AAC1617, changer le freekote 44-NC pour le  
Wolo

Produit additionnel

Numéro Job:



# Séq.: Machine ou Opération: Description :

1.0 AAC1616 N° 83634, Frekote Loctite Wolo

Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)  
N° 83634, Frekote Loctite Wolo # de Lot: 1-28909-1

2.0 PRÉPARATION Préparation du moule



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation du moule selon IF134-0020.

Date: Sceau:

3.0 AC0883 Tissu à délaminer Release ply B

Commentair Qty.: 9.84 VERGE(s)/Unit Total : 9.84 VERGE(s)

4.0 AC0884 Wrightlon 5200 Bleu P3

Commentair Qty.: 9.27 VERGE(s)/Unit Total : 9.27 VERGE(s)

5.0 AC0885 Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)

6.0 AC0943 Stretchlon 200 poche à vide Vert

Commentair Qty.: 7.00 VERGE(s)/Unit Total : 7.00 VERGE(s)

7.0 AMB0214 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 11.4 VERGE(s)/Unit Total : 11.4 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-30234-1

Date: . Jeudi, 2011-04-21 11:52:58  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 32822

Nom Dessin: SPACEPOD BODY RH  
Numéro Article: DKC134-0071

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

8.0	AMB0349	Fiberglass 12 oz Unidirectional
-----	---------	---------------------------------

Commentair Qty.: 0.80 VERGE(s)/Unit Total : 0.80 VERGE(s)  
Fiberglass 12 oz Unidirectional N° de Lot: 1-22549-1

9.0	AMB0213	WR1850 Roving 18oz. x 50"
-----	---------	---------------------------

Commentair Qty.: 0.350 KILOGRAMME(s)/Unit Total : 0.350 KILOGRAMME(s)  
WR1850 Roving 18oz. x 50" N° de Lot: 1-28778-1

10.0	AC0886	Ruban à gommer jaune #: T/AT-200Y
------	--------	-----------------------------------

Commentair Qty.: 4.0000 ROULEAU(s)/Unit Total : 4.0000 ROULEAU(s)

11.0	PREP-GENERAL	Préparation du matériel
------	--------------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Tailler les tissus selon IF134-0020.

Date: 05/05/11 Sceau:



12.0	AMB0286	Catalyst N° DDM-9
------	---------	-------------------

Commentair Qty.: 0.0640 GALLON(s)/Unit Total : 0.0640 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-27829-1

13.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
------	---------	---

Commentair Qty.: 2.000 LITRE(s)/Unit Total : 2.000 LITRE(s)  
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-32912-1

14.0	AAC1540	Fibre de verre Miapoxy 66
------	---------	---------------------------

Commentair Qty.: 0.0040 GALLON(s)/Unit Total : 0.0040 GALLON(s)  
Fibre de verre Miapoxy 66 N° de Lot: 1-31393-1

15.0	PREP-GENERAL	Préparation du matériel
------	--------------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Laminer la 1ère coquille selon IF134-0020.

Date: 10/11/11 Sceau:



16.0	AMB0033	ATC core-cell A500 plain 4'x8' 1" thick
------	---------	---

Commentair Qty.: 0.750 FEUILLE(s)/Unit Total : 0.750 FEUILLE(s)  
ATC core-cell A500 plain 4'x8' 1" thick N° de Lot: 1-26978-2

17.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
------	---------	---

Commentair Qty.: 0.200 LITRE(s)/Unit Total : 0.200 LITRE(s)  
Résine (411B7530) 411-350 promo. 75min. N° de Lot: N/A

Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD BODY RH

Numéro Job: 32822

Numéro Article: DKC134-0071

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

18.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0064 GALLON(s)/Unit Total : 0.0064 GALLON(s)

Catalyst N° DDM-9 N° de Lot: N/A

19.0

AAC1611

Polybond B46F

Commentair Qty.: 0.010 KIT(s)/Unit Total : 0.010 KIT(s)

Polybond B46F N° de Lot: N/A

20.0

TAILLAGE

Faire le taillage du matériel



Commentair Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs

Tailler et ajuster les Foam Core selon IF134-0020.

Date: 24-5-11

Sceau:



21.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 LITRE(s)/Unit Total : 0.300 LITRE(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-30828-4

22.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0096 GALLON(s)/Unit Total : 0.0096 GALLON(s)

Catalyst N° DDM-9 N° de Lot: 1-27829-1

23.0

FINITION

Finition Générale



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Sceller les foam core selon IF134-0020.

Date: 24-5-11

Sceau:



24.0

PERCAGE

Perçage de trous



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Percer les foam core selon IF134-0020.

Date: 25-5-11

Sceau:



25.0

AAC1611

Polybond B46F

Commentair Qty.: 0.078 KIT(s)/Unit Total : 0.078 KIT(s)

Polybond B46F

N° de Lot: 1-27795-1

Date: Jeudi, 2011-04-21 11:52:58  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 32822

Nom Dessin: SPACEPOD BODY RH  
Numéro Article: DKC134-0071

Numéro Job:



# Ség.:

Machine ou Opération:

Description :

26.0

ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Installer les foam core selon IF134-0020.

Date: 14-11-11 Sceau:



27.0

AAC1492

N° P-15-3, Adtech Micro Ultra Filler

Commentair Qty.: 0.050 GALLON(s)/Unit Total : 0.050 GALLON(s)  
N° P-15-3, Adtech Micro Ultra Filler # de Lot: 1-33224-1

28.0

FINITION

Finition Générale



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Usiner les foam core selon IF134-0020.

Date: 16/11/11 Sceau:



29.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.600 KILOGRAMME(s)/Unit Total : 1.600 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-33219-1

30.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0536 GALLON(s)/Unit Total : 0.0536 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-27829-1

31.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

Laminer les plis de 9oz selon IF134-0020.

Date: 17/11/11 Sceau:



32.0

TRIMAGE

Trimage



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Faire le taillage selon IF134-0022.

Date: 18/11/11 Sceau:



Date: Jeudi, 2011-04-21 11:52:58  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 32822

Nom Dessin: SPACEPOD BODY RH  
Numéro Article: DKC134-0071

Numéro Job:



# Séq.: Machine ou Opération: Description :

33.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0144 GALLON(s)/Unit Total : 0.0144 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27929-1

34.0 AAC1540 Fibre de verre Miapoxy 66

Commentair Qty.: 0.0420 GALLON(s)/Unit Total : 0.0420 GALLON(s)

Fibre de verre Miapoxy 66

N° de Lot: ~~1-33219-1~~ 1-2956-1

35.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.450 KILOGRAMME(s)/Unit Total : 0.450 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-23219-1

36.0 LAMINAGE Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs

Faire le laminage des derniers plis 9oz selon IF134-0020.

22-11-11

Date: Sceau:



37.0 AAC1610 Spacer N° D2213

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)

Spacer N° D2213

N° de Lot: 1-33067-1

38.0 ASSEMBLAGE Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Faire l'assemblage des inserts selon IG 0097.

Date: 23-11-11 Sceau:



39.0 AAC1021 Dupont Primer N° 7704S

Commentair Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-30270-1

40.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot: 1-31394-2

41.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer la pièce selon IG 0008.

Quantité: 1 Date: 24-11-11 Sceau:



Date: Jeudi, 2011-04-21 11:52:59  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 32822

Nom Dessin: SPACEPOD BODY RH  
Numéro Article: DKC134-0071

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

42.0

PRIMER

Application primer



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer et appliquer le primer selon IG 0008.

Date: 24/05/11 Sceau:



# de fiche de mélange: N/A

43.0

AAC1492

N° P-15-3, Adtech Micro Ultra Filler

Commentair Qty.: 0.010 GALLON(s)/Unit Total : 0.010 GALLON(s)  
N° P-15-3, Adtech Micro Ultra Filler # de Lot: 1-33224-1

44.0

FINITION

Finition Générale



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

Faire les réparations de finition s'il y a lieu selon IG 0008.

25-11-11

Date: Sceau:



45.0

AAC1021

Dupont Primer N° 7704S

Commentair Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s)  
Dupont Primer N° 7704S N° de Lot: 1-30270-1

46.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)  
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-31394-2

47.0

PRIMER

Application primer



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer et appliquer le primer selon IG 0008.

Date: 25/05/11 Sceau:



# de fiche de mélange: N/A

48.0

INSPEC FINAL

Inspection finale



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'inspection générale de la pièce selon le dessin par le département de la qualité.

Date: 28-11-11

Sceau:



Initiales: P.S.

Date: Jeudi, 2011-04-21 11:52:59  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 32822

Nom Dessin: SPACEPOD BODY RH  
Numéro Article: DKC134-0071

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

49.0

EMBALLAGE

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'emballage selon IG 005



Date: 28-11-11 Sceau: